

May-31-12 1:09:15 PM

Page 1

Accept

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

6

Customer:

6

Reference:

Date: 12/05/31 Tooling:

Date:

Run Start *NR1*

QC:

Date: **SPC (Y/N):**

Date:

Stop ***NR2***

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85029

85029

Page 2

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Item ID: D3197-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bar Assembly

Start Date: 31/05/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Lathe Conv

CONVENTIONAL LATHE

0.00

SL 12/06/05

6

0

Memo

0.00

Conventional Lathe

Chamfer as per Dwg D3197

140

140

QC

QC8- Inspect parts - second check

0.00

mk 12/06/05

6

0

Memo

0.00

Quality Control

150

150

HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

CV

0

12/06/06

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 85029

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85029

Page 3

Item ID: D3197-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar Assembly

Start Date: 31/05/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

160

Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

M 121279

3200F

12:30

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

180

Small Fab

0.00

180

Small Fab

Memo

0.00

Small Fab

Assemble D3197-041 as per Dwg D3197

6X

MK
12/06/06

6x 1111106106

6x

ES
12/06/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 85029

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85029

Page 4

Item ID: D3197-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bar Assembly

Start Date: 31/05/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

5/26/12

76

Quality Control

200

Identify as per dwg & Stock Location: 260

0.00

200

Packaging

Memo

0.00

62

12/6/12

Packaging

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

12/6/20

Quality Control

MF
12-06-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 85029

85029

Parent Item: D3197-041

D3197-041

Parent Item Name: Bar Assembly

Start Date: 31/05/2012

Required Date: 14/06/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: A New Issue 05-11-08 JLM
IPP Rev: B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-24		Purchased	No			100	Each	90.0000	2	12			
MS27039-1-24										**			
Screw													

Location

Loc Qty

Loc Code

ST297

90

121912

90

180

Each

0.0000

6| | | | | | | | | | | | | | |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| 36 | | | | | | | | | | | | | |
| | | | | | | | | | | ** | | | |
| | | | | | | | | | | | | | |

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 85029

85029

Parent Item: D3197-041

D3197-041

Parent Item Name: Bar Assembly

Start Date: 31/05/2012

Required Date: 14/06/2012

Start Qty: 6.00

Required Qty: 6.00

D3489-3-200

Manufactured No

180

Each

3.0000

2

12

D3489-3-200

PIP PIN

**

Location

Loc Qty

Loc Code

GA

3

84853

3

180

f

35.2250

2.42

18.15

**

M7075T73R1.000

Purchased

No

M7075T73R1 000

7075-T73 Rd Bar 1.00

Location

Loc Qty

Loc Code

MAT012

35.225

120503

21.375

→ 120568

13.85

180

Each

2,300.000

2

12

**

MS21042L3

Purchased

No

MS21042L3

Nut

Location

Loc Qty

Loc Code

ST300

2300

117885

32

119017

1019

119075

138

121349

259

121444

852

12

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	85029
Description: Bar		Part Number:	D3197-1
Inspection Dwg: D3197	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.00	/		m-tape	
25.06	+/-0.030	25.06	/			
11.44	+/-0.030	11.450	/		vern	CNC-82
0.500	+/-0.010	.501	/		"	JL-10
0.250	+/-0.030	.260	/		"	"
Ø0.219	+0.005/-0.000	.220	/		"	"
Ø0.191	+0.005/-0.000	.192	/		"	"
1.000	+/-0.005	1.000	/		"	"
2.69	+/-0.030	2.687	/		"	"
1.000	+/-0.010	1.000	/		"	"
0.300	+/-0.010	.304	/		"	"
0.063 x 45°	+/-0.010	.065x45°	/		"	"
Ø1.000	+/-0.010	.999	/		"	"

Measured by: JL	Audited by: amf	Prototype Approval:	N/A
Date: 12-06-05	Date: 12/06/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3197-041)	KJ/JLM	
B	07.03.09	Dwg revision update	KJ/JLM	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

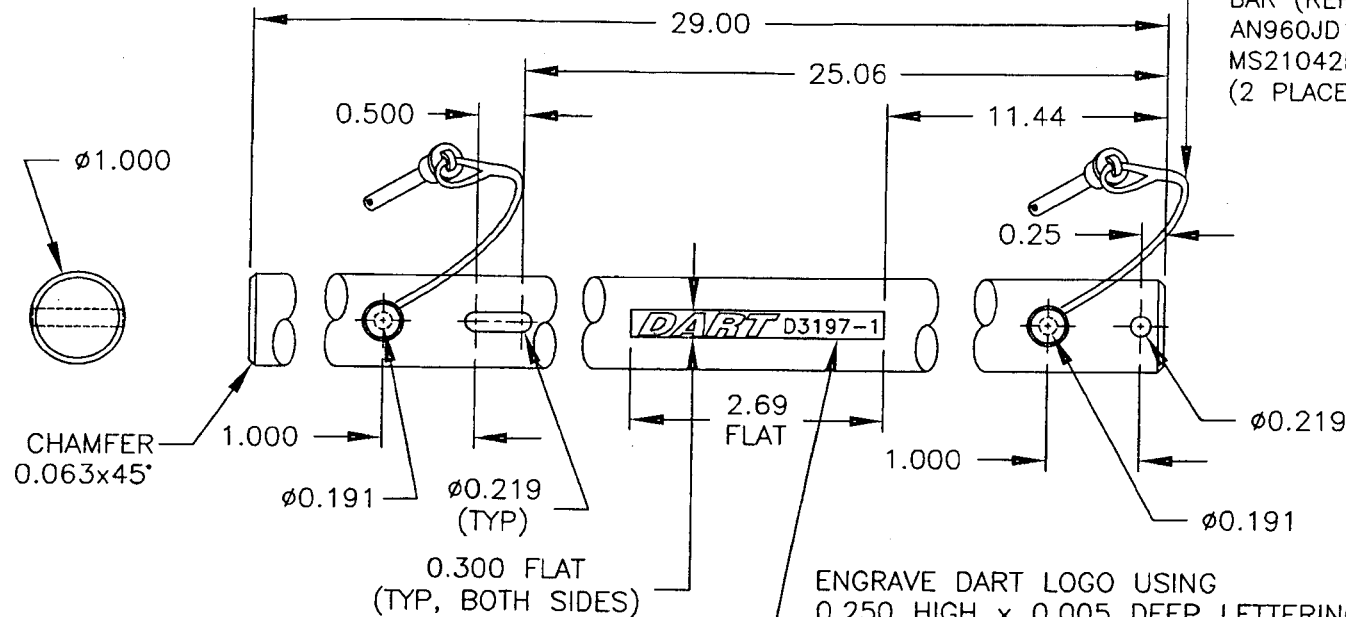
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED

DART

D3489-3-200 PIP PIN (1)
D3242-1 TAG (1)
MS27039-1-24 BOLT (1)
AN960JD10 WASHER (1)
D2690-5 LANYARD (1)
AN960JD10 WASHER (1)
BAR (REF)
AN960JD10 WASHER (1)
MS21042L3 NUT (1)
(2 PLACES)



D3197-041 BAR ASSEMBLY

ENGRAVE DART LOGO USING
0.250 HIGH x 0.005 DEEP LETTERING
AND P/N USING 0.150 HIGH x 0.005
DEEP LETTERING ON BOTH SIDES

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 85029

12/05/31

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.10	TITLE	BAR	REV. B
		DRAWING NO.	D3197	SHEET 1 OF 1
		NEW ISSUE		SCALE
		CHG PIP PIN; ADD D3242-1 TAG		1:1

D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) ϕ 1.000 O.D.
(REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER
END OF THE BAR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries